



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2332-041
Job Sheet 190278



Part No: D2332-041

Job Qty: 10 pcs

Part Name: Lid Prop Assembly 6.69"



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/6/19

Job Tracking No:

Due Date: 2/20/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C1 IPP: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF IPP Rev:C 08-06-02 add comment DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	10 pcs	2/20/19		0.32	3.13	Small Fab - 1		DAS 58 APR 03 2019 9-89
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	Small Fab - Brake NC - B4B	10 pcs	2/20/19		0.00	1.14	Small Fab - Brake - 1 - B4B		DAS 58 APR 03 2019 89
							Small Fab - Brake - 2 - B4B		
							Small Fab - Brake - 3 - B4B		
120	Small Fab - 2 - B4B	10 pcs	2/20/19		0.00	3.13	Small Fab - 1 - B4B		DAS 58 4/3/19 9-89
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
130	QC 5	10 pcs	2/20/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		

Plex 4/3/19 11:45 AM dart.boucher.sylvie

					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	<i>Q</i>
					QC 5 - 30	
140	Large Fab - Welded Assy-2-B4B	10 pcs	2/20/19	0.00 2.49	Large Fab - 1 - B4B	
					Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	<i>JBL</i>
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
150	QC 9	10 pcs	2/20/19	0.00 0.00	QC 9 - 10	
					QC 9 - 18	
					QC 9 - 24	
					QC 9 - 43	
					QC 9 - 50	<i>Q</i>
					QC 9 - 9	
160	QC 5	10 pcs	2/20/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 38	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	<i>Q</i>
					QC 5 - 30	
170	Small Fab - 3 - B4B	10 pcs	2/20/19	0.00 3.13	Small Fab - 1 - B4B	<i>DAS 58 APR 09 2019 9:00</i>
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
180	QC 5	10 pcs	2/20/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 38	
					QC 5 - 42	
					QC 5 - 43	

				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
190	Packaging 3-1 - Stock - B4B	10 pcs	2/20/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
200	QC 21 - SA	10 pcs	2/20/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

DAS
40
9-89

APR 09 2019

FP-001

21 14-4-9

DAS
21
9-89

APR 09 2019

Part Op **100** - (Small Fab) 1- Cut D2332-7 and D2332-5 to length as per dwg D2332. 2- Cut D2332-11 using 1/2" S.S tubing
 Descriptions: 7.735" long. 3- Deburr.

110 - (Punch ends and deburr as per dwg) Punch and form D2332-11 to length as per dwg D2332 using DT8012 (need 2 per ass'y)

120 - (Small Fab) 1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459 (drill one per ass'y) 2- Ensure no foreign objects inside tube

130 - (QC5- Inspect part completeness to step on W/O)

140 - (Weld per dwg A/R S.S. rod Batch: _____) Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y)

*****ensure nothing is inside of tube before welding***** S.S Rod batch: _____

150 - (QC9- Inspect visual per QSI004- Fusion Welds)

160 - (QC5- Inspect part completeness to step on W/O)

170 - (Small Fab) 1- Tumble 2- Assemble as per dwg D2332

180 - (QC5- Inspect part completeness to step on W/O)

190 - (Identify as per dwg & Stock Location: _____)

200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R0.250	304 SS Round bar .250	1 ft (.1 ea)	100-Small Fab - 1	5040 S135249
M304TR1.000W.049	304 Round Tube 1.00 X .049W	4.3000 ft (.43 ea)	100-Small Fab - 1	S135662
M304TR0.500W.035	304 Round Tube .500 X .035W	12.5000 ft (1.25 ea)	110-Small Fab - Brake NC - B4B	S145224 S169388
AN4-4A	Bolt	10 Ea (1 ea)	170-Small Fab - 3 - B4B	S148662
MS21042L4	Nut	10 Ea (1 ea)	170-Small Fab - 3 - B4B	S161968
NAS1149D0416J	Washer	30 Ea (3 ea)	170-Small Fab - 3 - B4B	fml3151H

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	M304R0.250	1	14	0
	M304TR1.000W.049	4	16	0
110-Small Fab - Brake NC - B4B	M304TR0.500W.035	13	89	0
170-Small Fab - 3 - B4B	AN4-4A	10	45	0
	MS21042L4	10	4,427	0
	NAS1149D0416J	30	2,052	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lid Prop Assembly	5.000Inches $\pm$ 0.030	5.030 4.970		
2	Lid Prop Assembly	1.250Inches $\pm$ 0.010	1.260 1.240		
3	Lid Prop Assembly	6.690Inches $\pm$ 0.010	6.700 6.680		

Plex 4/3/19 11:45 AM dart.boucher.sylvie



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA

TEL: 1 813 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S169396



Part: D2332-041

Job No: 190278

Serial No/Batch: S169396

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/03/19